

Work Order ID 133854

Monday, June 22, 2015 8:59:14 AM

133854

Page 1

Item ID: D3885-1 Accept ***N900040100*** Setup Start ***NS1***
Revision ID: Stop ***NS2***
Item Name: Standard Web
Start Date: 6/22/15 Start Qty: 10.00 ***10*** Cust Item ID:
Required Date: 6/26/15 Req'd Qty: 10.00 ***10*** Customer:
Reference:

Approvals: Process Plan: *[Signature]* Date: 5.6.22 Tooling: _____ Date: _____ Run Start ***NR1***
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D3885	B								

100

0.00

100

Purchasing

Memo

0.00

Purchasing

Purchasing

Issue P/O: 28926

Supplier: WEJAY

Machine as per Dwg D3885

Conformity sheet required

CL JUN 24 2015 10

110

Receive & Inspect for Damage & Mat'l Certs

0.00

110

Packaging

Memo

0.00

Packaging

CL 15/07/27 10

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date :	Step #:	QTY Effective :		MRB (QSI042) Approval	
Description Work Order Deviation		Disposition			
				Completed By	
				Lead hand / Supervisor Approval Verification	
				QC / QA Coordinator Approval	
Root Cause		FAULT CATEGORY			
Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐	No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐	Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐	Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐	Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Misabeled ☐ Fit/Function ☐ Misaligned/off center ☐	Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐
☐ OTHER : _____					

Monday, June 22, 2015 8:59:14 AM

Page 2

Quality Control

(W) 15-07-27

 DAS
 9
 9-85

10 15-7-27 *[Signature]* 1/202

10 β β_F 1507.27

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

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Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
150	Identify as per dwg & Stock Location <u>LG002</u>	0.00							
150									
Packaging	Memo	0.00							
Packaging	LOCATION : LG002								
160	QC21- Final Inspection - Work Order Release	0.00							
160									
QC	Memo	0.00							
Quality Control									

15-727
15/7/28
15-727

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

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Work Order update only ☐

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Picklist Print

Monday, June 22, 2015 8:59:19 AM

Page 1

Work Order ID: 133854

133854

Parent Item: D3885-1

D3885-1

Parent Item Name: Standard Web

Start Date: 6/22/15

Required Date: 6/26/15

Start Qty: 10.00

Required Qty: 10.00

Comments: IPP RevA: New issue DD verified by:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D3885-1P		Purchased	No				Each	0.0000		10			
D3885-1P										**	CY 15/07/27		
Standard Web													
D3882-1-130		Manufactured	No			110	Each	53.0000	1	10			
D3882-1-130										**	DP 15-6-22		
Extrusion "I" Beam													
			<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>						
			LG002		53								
			119702		53				10				

10

CY 15/07/27

DP 15-6-22

10

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

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D3885-1 STANDARD WEB

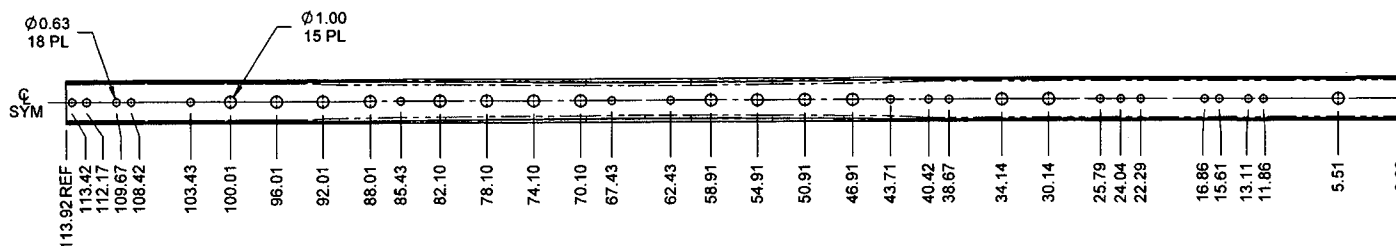
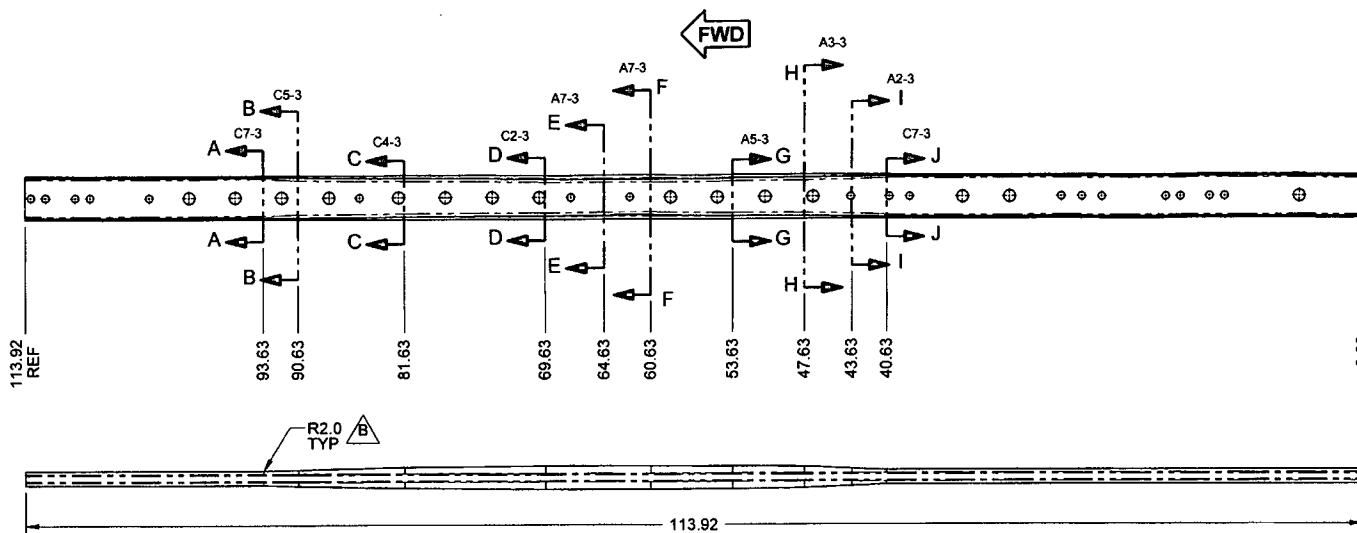
D3885-3 FLOAT WEB

RELEASED
09/07/15

Handwritten: 15.6-22

B	ADD 0.32 (ZN D7-3, D5-3, D7-5, D5-5); ADD 0.24 (ZN B2-3, B3-5), ADD R2.0 TYP (ZN C6-2 & C6-4)	RF	09.06.30
A	NEW ISSUE	RF	09.03.30
REV.	DESCRIPTION	BY	DATE
DESIGN	RF	DART AEROSPACE USA, INC.	
DRAWN	RF	PORT HADLOCK, WA	
CHECKED	<i>[Signature]</i>	DRAWING NO.	REV. B
MFG. APPR.	<i>[Signature]</i>	D3885	SHEET 1 OF 5
APPROVED	<i>[Signature]</i>	TITLE	SCALE
DE APPR.	<i>[Signature]</i>	WEB	NTS
DATE	09.06.30	COPYRIGHT © 2009 BY DART AEROSPACE USA, INC. THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.	

8 7 6 5 4 3 2 1



D3885-1 STANDARD WEB

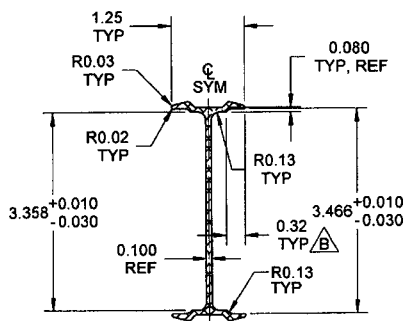
RELEASED
09/07/15

D3885-1 NOTES:

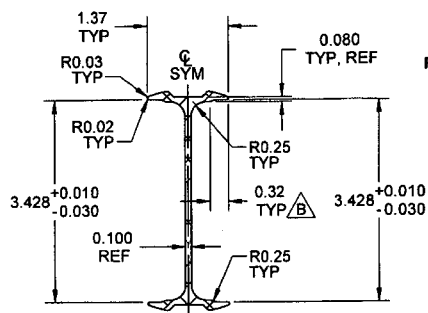
- 1) MATERIAL: MAKE FROM D3882-1-130 EXTRUSION
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3885-1" USING FINE POINT PERMANENT INK MARKER
- 7) WEIGHT: 8.51 lbs

DESIGN	RF	DART AEROSPACE USA, INC.	
DRAWN	RF	PORT HADLOCK, WA	
CHECKED		DRAWING NO.	REV. B
MFG. APPR.		D3885	SHEET 2 OF 5
APPROVED		TITLE	SCALE
DE APPR.		WEB	NTS
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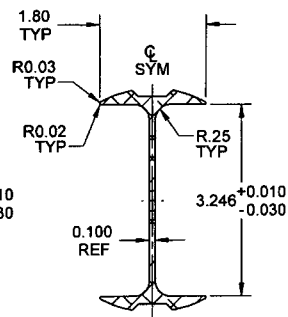
8 7 6 5 4 3 2 1



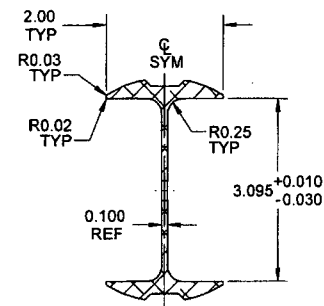
**SECTION A-A
& SECTION J-J** D6-2
SCALE 5X D4-2



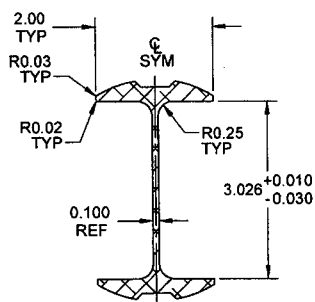
SECTION B-B D6-2
SCALE 5X



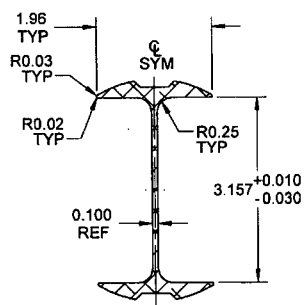
SECTION C-C D6-2
SCALE 5X



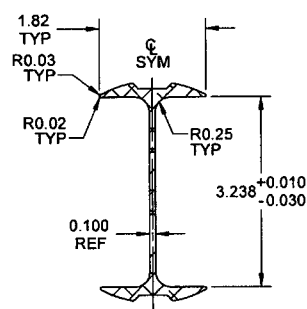
SECTION D-D D6-2
SCALE 5X



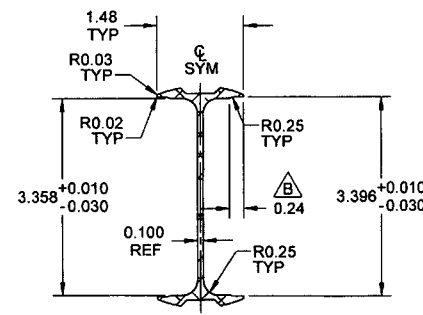
**SECTION E-E
& SECTION F-F** D5-2
SCALE 5X



SECTION G-G D4-2
SCALE 5X



SECTION H-H D4-2
SCALE 5X

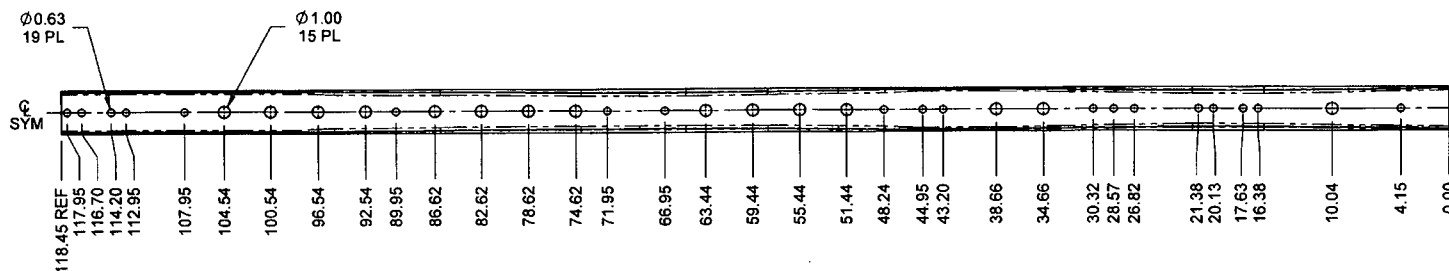
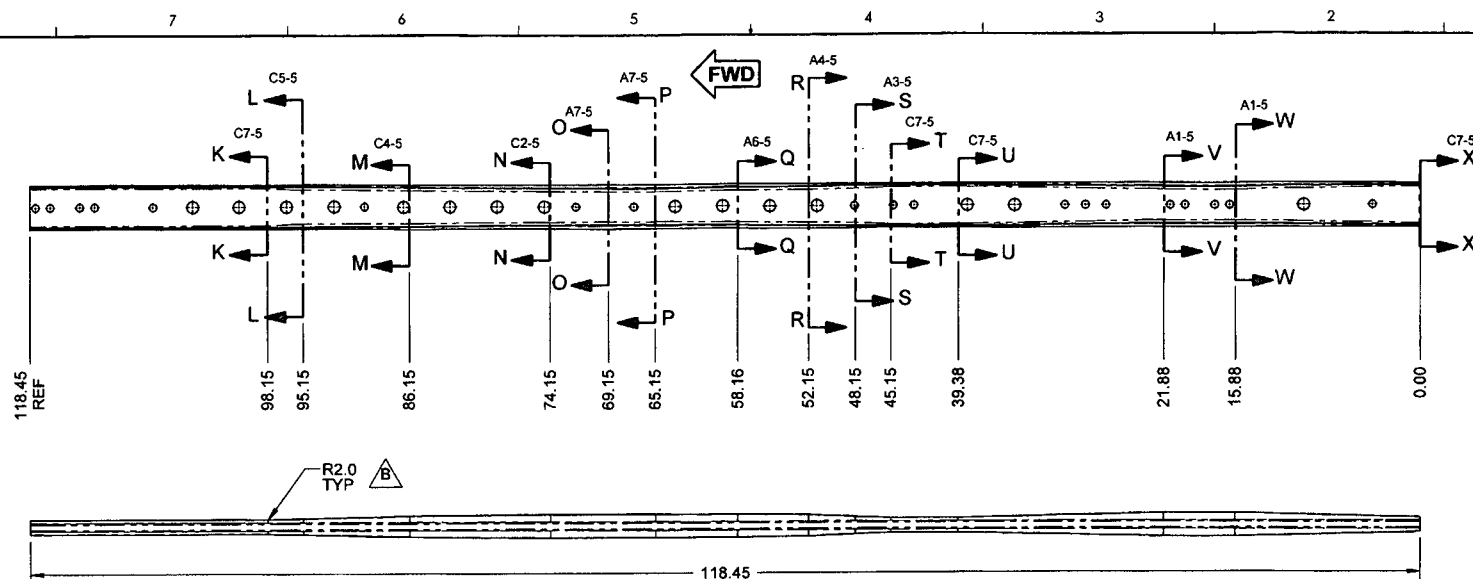


SECTION I-I D4-2
SCALE 5X

D3885-1 STANDARD WEB SECTION VIEWS

RELEASED
9/6/15 MB

DESIGN	RF	DART AEROSPACE USA, INC.	
DRAWN	RF	PORT HADLOCK, WA	
CHECKED		DRAWING NO. D3885	REV. B
MFG. APPR.			SHEET 3 of 5
APPROVED		TITLE	SCALE
DE APPR.		WEB	NTS
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D3885-3 FLOAT WEB

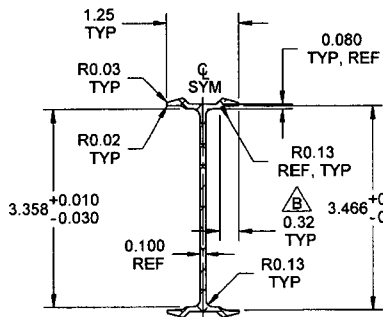
RELEASED
09/07/15/16

D3885-3 NOTES:

- 1) MATERIAL: MAKE FROM D3882-1-130 EXTRUSION
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3885-3" USING FINE POINT PERMANENT INK MARKER
- 7) WEIGHT: 10.14 lbs

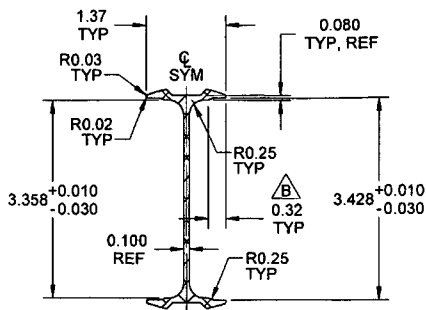
DESIGN	RF	DART AEROSPACE USA, INC.	
DRAWN	RF	PORT HADLOCK, WA	
CHECKED		DRAWING NO.	REV. E
MFG. APPR.		D3885	SHEET 4 OF 5
APPROVED		TITLE	SCALE
DE APPR.		WEB	NTS
DATE	09.06.30	COPYRIGHT © 2009 BY DART AEROSPACE USA, INC.	
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8 7 6 5 4 3 2 1

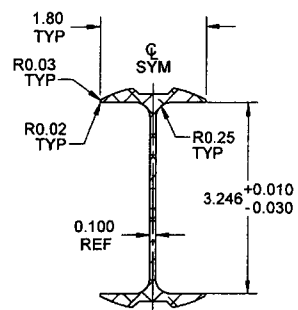


**SECTION K-K
& SECTION T-T
& SECTION U-U
& SECTION X-X**
SCALE 5X

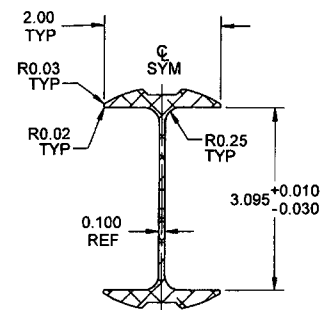
D7-4
D4-4
D3-4
D1-4



SECTION L-L D6-4
SCALE 5X

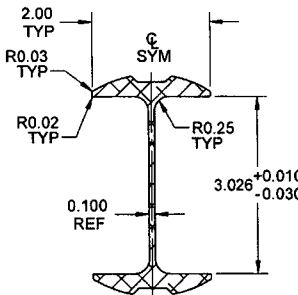


SECTION M-M D6-4
SCALE 5X

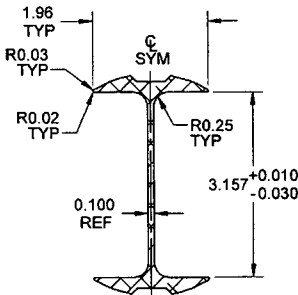


SECTION N-N D5-4
SCALE 5X

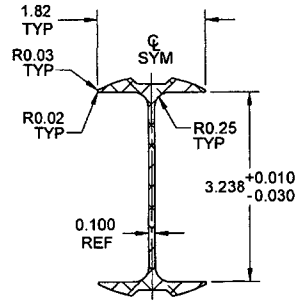
RELEASED
9/15/14



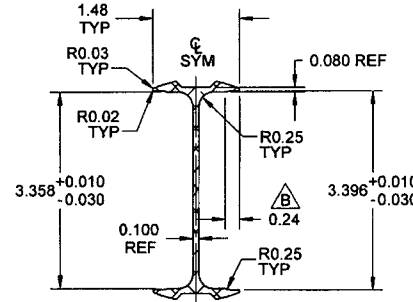
**SECTION O-O
& SECTION P-P** D5-4
SCALE 5X



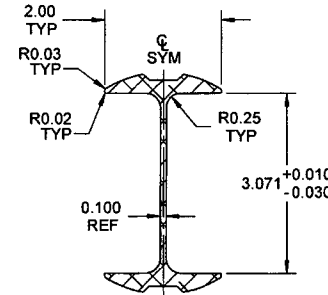
SECTION Q-Q D4-4
SCALE 5X



SECTION R-R D4-4
SCALE 5X



SECTION S-S D4-4
SCALE 5X



**SECTION V-V
& SECTION W-W** D3-4
SCALE 5X

D3885-3 FLOAT WEB SECTION VIEWS

DESIGN	RF	DART AEROSPACE USA, INC.	
DRAWN	RF	PORT HADLOCK, WA	
CHECKED	RF	DRAWING NO.	REV. B
MFG. APPR.		D3885	SHEET 5 OF 5
APPROVED		TITLE	SCALE
DE APPR.		WEB	NTS
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8 7 6 5 4 3 2 1



Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
Tel: 613 632 9577
Fax: 613 632 1053

PURCHASE ORDER

Purchase Order ID **PO28926**

Purchase Order Date 6/24/2015

PO Print Date 6/24/2015

Page Number 1 of 2

Order From :

VC-WMP001

WEJAY MACHINE PRODUCTS CO. LTD
600 O'CONNOR DRIVE
KINGSTON, ONTARIO K7P 1N3
CANADA

Ship To :

DART AEROSPACE LTD

1270 ABERDEEN
HAWKESBURY, ON K6A 1K7
CANADA

Contact Name

Vendor Phone

613-384-1662

Ship To Contact

Ship To Phone

Ship Via:

Day & Ross collect

Ship Acct:

Buyer

Chantal Lavoie

Customer POID

Customer Tax #

10127-2607

Terms

Net 30

Currency

CAD

FOB

Destination-Collect

Line Nbr	Reference Vendor Part Number Line Comments Delivery Comments	Description/ Mfg ID	Req Date/ Taxable Promise Date	CD	Req Qty/ Unit of Measure	PO Unit Price	Extended Price
1	D3885-1P AS PER DWG D3885 REV. B B133854	Standard Web	7/27/2015 Yes 7/27/2015		10.00 Each	\$520.00	\$5,200.00
Line Total:							\$5,200.00
2	D5085-1P AS PER DWG D5085 REV. A B130107	Web	7/27/2015 Yes 7/27/2015	FN	6.00 Each	\$945.00	\$5,670.00
Line Total:							\$5,670.00

PO Instructions: QUOTATION NO. WJ-8557, WJ-8455

Note:

6/24/2015



Packing Slip 37433

600 O'CONNOR DRIVE, KINGSTON, ONTARIO K7P 1N3
 TEL: 613-384-1662 FAX: 613-384-2997
 www.wejay.com

SOLD TO: Dart Aerospace
 1270 Aberdeen Street
 Hawkesbury ON K6A 1E7

SHIP TO: Dart Aerospace
 1270 Aberdeen Street
 Hawkesbury ON K6A 1E7

INVOICE DATE	YOUR ORDER NO. 80128926	DATE ORDERED 06/24/15	SHIPPED VIA Best way
CUSTOMER CODE	PROV. LIC. NO.	Extra ☐ Exempt ☐	TERMS

QUANTITY ORDERED	B.O.	QUANTITY SHIPPED	DESCRIPTION	UNIT PRICE	AMOUNT
0		10	Fabricate standard web as per drawing D3885 Rev. B Part ID: D3885-1P B133854		
6		0	Fabricate float web as per drawing D5085 Rev. B Part ID: D5085-1P B130107		
Required by: July 27, 2015 RELEASE NOTE I certify that the items listed hereon have been inspected and tested and conform to all specifications and requirements in the contract or purchase order. Inspection Supervisor <i>[Signature]</i> WMP 03 <i>July 23/15</i>					
G.S.T.					
P.S.T.					

ORDER: COMPLETE ☐
 PARTIAL ☐

TOTAL

RECEIVED BY _____
 1.5% PER MONTH (18% PER ANNUM)
 CHARGED ON OVERDUE ACCOUNTS

NO GOODS RETURNED WITHOUT
 PRIOR AUTHORIZATION



600 O'CONNOR DRIVE, KINGSTON, ONTARIO K7P 1N3

PHONE: (613) 384-1662

FAX: (613) 384-2997

CERTIFICATE OF COMPLIANCE

CUSTOMER: Dart Aerospace		DATE: July 23, 2015	
		P.O.# PO28926	
		WEJAY JOB# 37433	
I hereby certify that the following material has been inspected/tested and conforms to the requirements and specifications as stated in your contract and as noted below. Any exceptions will be listed as NCR items.			
PART NO.	QTY.	PROCESS (ES)	SPECIFICATION / REV
D3885-1 'Standard Web' Dart ID: D3885-1P	10	Machined complete per drawing req'ts. CL15107127	D3885-1P / rev. B
<u>Note:</u> 1st Article Inspection Report attached.			

Records of Inspection/Test will be retained for 5 years minimum.

Yours truly,



Clifford Smith

Authorized Q.A. Signatory

INSPECTION / TEST REPORT						JOB No. 37433 PAGE: 2 of 3	
CUSTOMER: Dart Aerospace							
CUST. P.O. PO 28926							
PART No. D3885-1				DESCRIPTION: Standard Web			
DWG No. D3885 - sheets 2-3				REV. B		E.C.O. --	
REF. No.	CHARACTERISTIC	DETAILS	TOLERANCE	DWG SHT/ZONE	RESULT	QTY. INSP.	COMMENTS (ACC. REJ. REW. NMR #)

33	109.67"		+/- .03		O.K.	1	ACCEPTED
34	112.17"		+/- .03		O.K.	1	"
35	113.42"		+/- .03		O.K.	1	"
36	113.92" o.a.		+/- .03		113.924 (CALC.)	1	"
37	1.25" TYP	Section A-A, J-J	+/- .03		1.247-1.265	1	"
38	R.03" TYP				O.K.	1	"
39	R.02" TYP				O.K.	1	"
40	3.358"		+0.010/-0.030		3.348-3.354	1	"
41	R.13" TYP				R.125 TYP.	1	"
42	.32" TYP		+/- .03		.32 TYP.	1	"
43	3.466"		+0.010/-0.030		3.445-3.451	1	"
44	R.13" TYP				R.125 TYP.	1	"
45	.080 TYP, REF				O.K.	1	"
46	1.37" TYP	Section B-B	+/- .03		1.386-1.390	1	"
47	R.03" TYP				O.K.	1	"
48	R.02" TYP				O.K.	1	"
49	3.358"		+0.010/-0.030		3.351-3.358	1	"
50	R.25" TYP				R.25 TYP.	1	"
51	.32" TYP		+/- .03		.32 TYP.	1	"
52	R.25" TYP				O.K.	1	"
53	3.428"		+0.010/-0.030		3.415-3.425	1	"
54	1.80" TYP	Section C-C	+/- .03		1.815-1.820	1	"
55	R.03" TYP				O.K.	1	"
56	R.02" TYP				O.K.	1	"
57	3.246"		+0.010/-0.030		3.232-3.248	1	"
58	R.25" TYP				R.25 TYP.	1	"
59	2.00" TYP	Section D-D	+/- .03		1.986 TYP.	1	"
60	R.03" TYP				O.K.	1	"
61	R.02" TYP				O.K.	1	"
62	3.095"		+0.010/-0.030		3.080-3.098	1	"
63	R.25" TYP				R.25 TYP.	1	"
64	2.00" TYP	Section E-E, F-F	+/- .03		1.986 TYP.	1	"
65	R.03" TYP				O.K.	1	"
66	R.02" TYP				O.K.	1	"
67	3.026"	(STOCK DIM)	+0.010/-0.030		3.021-3.040	1	"
68	R.25" TYP				R.25 TYP.	1	"
69	1.96"	Section G-G	+/- .03		1.985	1	"
70	R.03" TYP				O.K.	1	"
71	R.02" TYP				O.K.	1	"



600 O'CONNOR DRIVE
KINGSTON, ONTARIO
K7P 1N3

INSPECTION / TEST REPORT

JOB No. 37433

PAGE: 1 of 3

CUSTOMER: Dart Aerospace

CUST. P.O.# PO 28926

PART No. D3885-1

DESCRIPTION: Standard Web

DWG No. D3885 - sheets 2-3

REV. B

E.C.O. --

MATERIAL: Extrusions supplied by DAS

INSPECTOR:

CLIFF SMITH WMP

QUANTITY
REC'D: 1

ACCEPT: 1

REJECT: --

N.C.R.# --

DATE:

JULY 14/15

03

INSTRUCTIONS, COMMENTS:

FIRST ARTICLE INSP.

ITEM REF. No.	CHARACTERISTIC	DETAILS	TOLERANCE	DWG SHT/ZONE	RESULT	QTY. INSP.	COMMENTS (ACC. REJ. REW. NMR #)
1	Hole, Diameter .63"	18 places	+ .008/- .001		.631-.632	1	ACCEPTED
2	Hole, Diameter 1.00"	15 places	+ .010/- .001		1.001-1.003	1	"
3	5.51"		+/- .03		5.5105	1	"
4	11.86"		+/- .03		O.K.	1	"
5	13.11"		+/- .03		O.K.	1	"
6	15.61"		+/- .03		O.K.	1	"
7	16.86"		+/- .03		O.K.	1	"
8	22.29"		+/- .03		O.K.	1	"
9	24.04"		+/- .03		O.K.	1	"
10	25.79"		+/- .03		O.K.	1	"
11	30.14"		+/- .03		O.K.	1	"
12	34.14"		+/- .03		O.K.	1	"
13	38.67"		+/- .03		O.K.	1	"
14	40.42"		+/- .03		O.K.	1	"
15	43.71"		+/- .03		O.K.	1	"
16	46.91"		+/- .03		O.K.	1	"
17	50.91"		+/- .03		O.K.	1	"
18	54.91"		+/- .03		O.K.	1	"
19	58.91"		+/- .03		O.K.	1	"
20	62.43"		+/- .03		O.K.	1	"
21	67.43"		+/- .03		O.K.	1	"
22	70.10"		+/- .03		O.K.	1	"
23	74.10"		+/- .03		O.K.	1	"
24	78.10"		+/- .03		O.K.	1	"
25	82.10"		+/- .03		O.K.	1	"
26	85.43"		+/- .03		O.K.	1	"
27	88.01"		+/- .03		O.K.	1	"
28	92.01"		+/- .03		O.K.	1	"
29	96.01"		+/- .03		O.K.	1	"
30	100.01"		+/- .03		O.K.	1	"
31	103.43"		+/- .03		O.K.	1	"
32	108.42"		+/- .03		O.K.	1	"